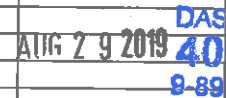




Michel AP 2019/08/29



					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC GA192
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	15 pcs	8/26/19	0.00 0.00	QC 21 - FG - 21	21 SEP 13 2019
					QC 21 - FG - 70	21 SEP 13 2019
					QC 21 - SA - 53	21 SEP 13 2019

Part Op 100 - Small Fab - 1-Assemble as per DWG sheet 1. ***Note 32446 22-16 crimp connectors supplied loose as per note

Descriptions: 1***

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ - Bag and tag

140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
32446	Crimp Terminal	30 Ea (2 ea)	100-Small Fab - 1	5074209
92373A143	Spring Pin	15 Ea (1 ea)	100-Small Fab - 1	5060927
C3-8-2-1	Solenoid	15 pcs (1 ea)	100-Small Fab - 1	5161522
C3-8-2-2	Solenoid Pin Spacer	15 pcs (1 ea)	100-Small Fab - 1	5120952
C3-8-3-1	Spacer	15 pcs (1 ea)	100-Small Fab - 1	5104175

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	32446	30	676	0
	92373A143	15	41	0
	C3-8-2-1	15	9	0
	C3-8-2-2	15	0	0
	C3-8-3-1	15	29	0

Part Specifications	
Specifications could not be found.	

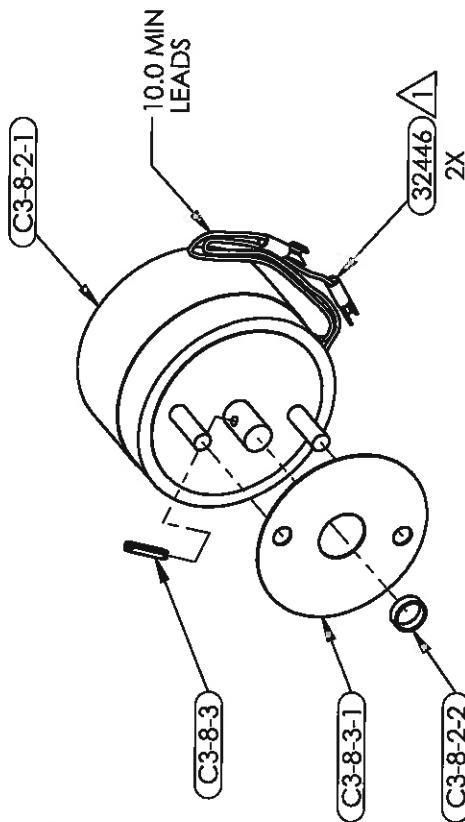
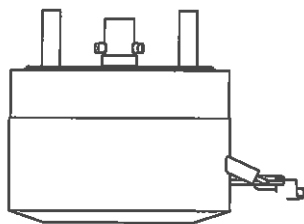
Plex 7/25/19 8:44 AM Dart.Renwick.Jennifer

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C3-8-31.	10/10/2012	RJC	DW
1A	14-0111	CHD TITLE BLOCK WAS RED BARN IS DART. ADDED ENGRAVE NOTE Δ .	8/7/2014	DJN	RW
2	14-0195	C3-8-2-1 CHD DIM WAS LIMITS $\varnothing$.0933-.0937 IS LIMITS $\varnothing$.094-.097. ADDED "CLOCKWISE" TO NOTE Δ . CHD NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTAL SPACER. AND PIN IN PLACE AS SHOWN ON SHEET 1. AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE. C3-8-3-1 CHD DIM WAS $\varnothing$.2285 IS $\varnothing$.195. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/23/2014	DPD	JAG
3	15-0243	UPDATED TO NEW DRAFTING STANDARDS. C3-8-3-2 DELETED; REPLACED WITH 32446.	8/25/2015	DPD	JAG

REF: .060 AXIAL STROKE



NOTE:

Δ CONNECTIONS SUPPLIED LOOSE.

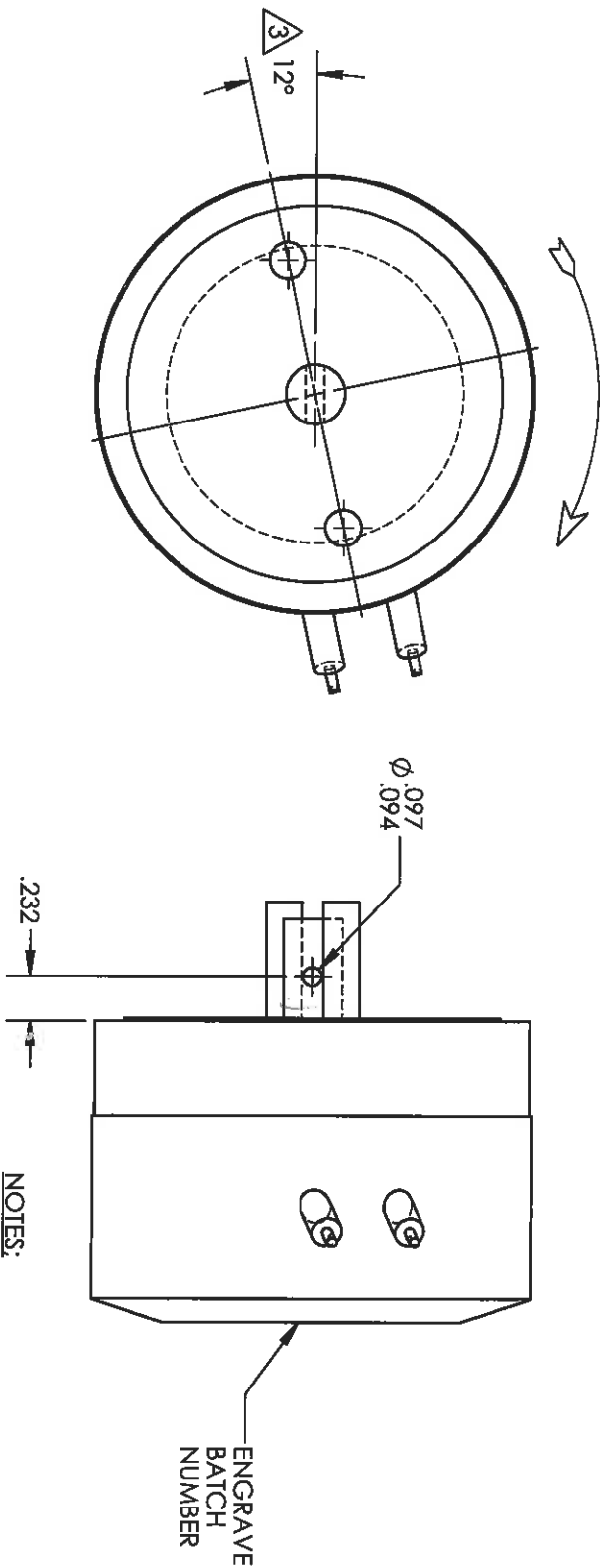


SOLENOID ASSEMBLY

ASSY QTY	ASSY B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	MAT'L	DWG NO.	TITLE	REV
	B/O	C3-8-2-1	1	SOLENOID		TESTCO # 152951-001	1,2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm$ 1/8 DECIMALS $\pm$.01 ANGLES $\pm$.5° 1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	C3-8-2	SOLENOID ASSEMBLY	3
	B/O	C3-8-2-2	1	SOLENOID PIN SPACER	303 S.S.		3				
	B/O	C3-8-3	1	SPRING PIN	18-8 S.S.		1				
	B/O	C3-8-3-1	1	SPACER	PETG		4				
	B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	140195	C3-8-2-1 CHD DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "CLOCKWISE" TO NOTE 3. CHD NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG



NOTES:

1. USE C3-8-2-FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

DART
AEROSPACE

SOLENOID ASSEMBLY

TITLE
DWG NO. C3-8-2
REV 3

MAT'L

DRAWN BY: CANAM

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS $\pm 1/8$
DECIMALS $\pm .01$
ANGLES $\pm .5^\circ$

1. BREAK ALL SHARP EDGES .015 x 45°
OR .075R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

3. USED ON MODEL

4. USED ON MODEL

5. USED ON MODEL

6. USED ON MODEL

7. USED ON MODEL

8. USED ON MODEL

9. USED ON MODEL

10. USED ON MODEL

11. USED ON MODEL

12. USED ON MODEL

13. USED ON MODEL

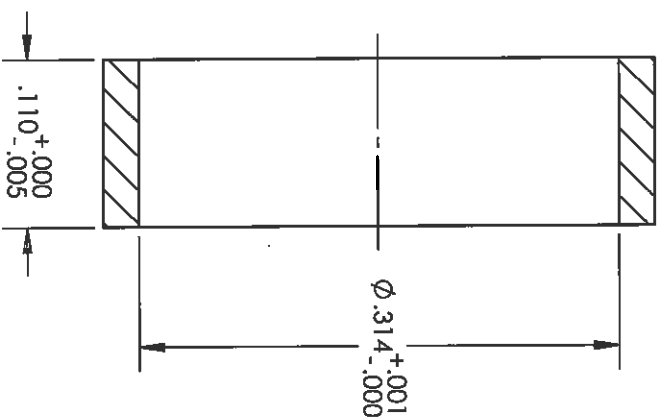
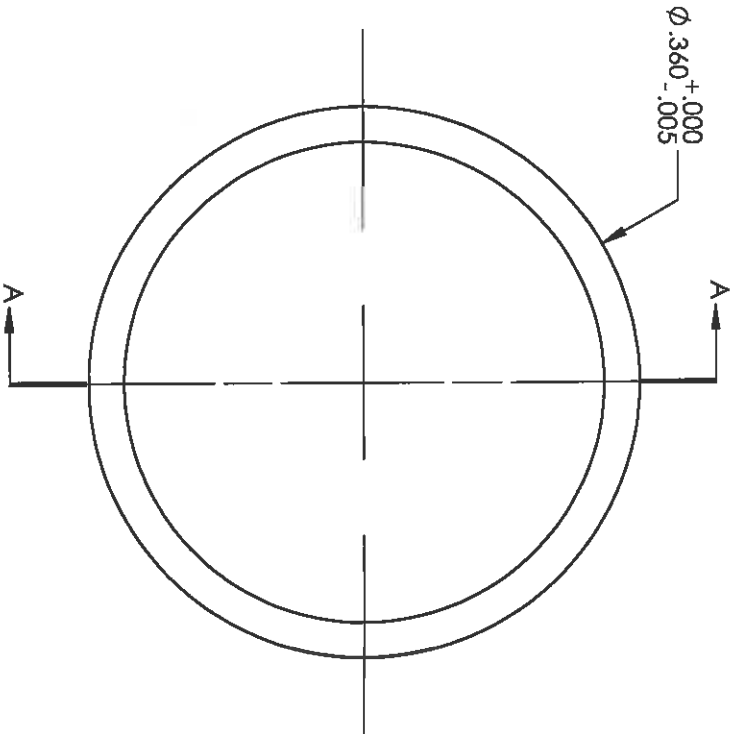
C3-8-2-1

SOLENOID WITH PINNED HOLE

SCALE 1:1 DATE 12/19/2001 SHEET 2 OF 4

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL / APPROVED



SECTION A-A



SOLENOID ASSEMBLY

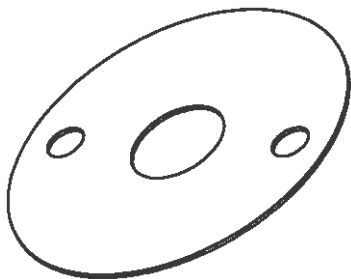
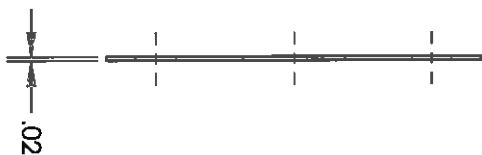
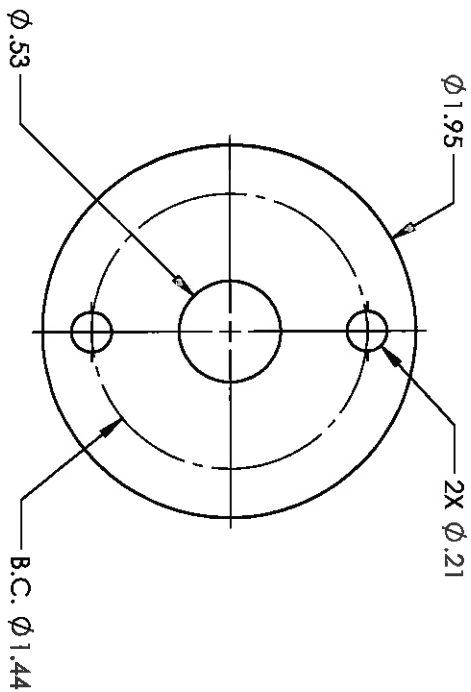
TITLE		DWG NO.	
C3-8-2		3	
MATERIAL: 303 S.S.		DRAWN BY: CANAM	
UNLESS OTHERWISE SPECIFIED		APPROVED: <i>[Signature]</i>	
DIMENSIONS ARE IN INCHES		FINISH: <i>[Signature]</i>	
FRACTIONS 1/8		SPEC: <i>[Signature]</i>	
ANGLES 15°		USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 X 45°			
2. DIMENSIONAL LIMITS APPLY AFTER FLATTING			
SCALE	DATE	SHEET 3 OF 4	
8:1	10/31/2001		

C3-8-2-2

SPACER

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C-3-8-3-1	10/10/2012	RJC	DW
2	14-0195	C3-8-3-1 CHD DIM WAS Ø2.285 IS Ø1.95.	10/23/2014	DPD	JAG



DART
AEROSPACE

TITLE: SOLENOID ASSEMBLY

DWG NO. C3-8-2

REV 3

MATL. DETG. DRAWN BY: APPROVED: *D. Muel*

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS $\frac{1}{8}$
XX $\frac{1}{4}$.43
X $\frac{1}{16}$.06
ANGLES $\pm .5^\circ$
SPEC
1. BREAK ALL SHARP EDGES .015 X 45°
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

SCALE 1:1 DATE SHEET 4 OF 4

C3-8-3-1
SPACER